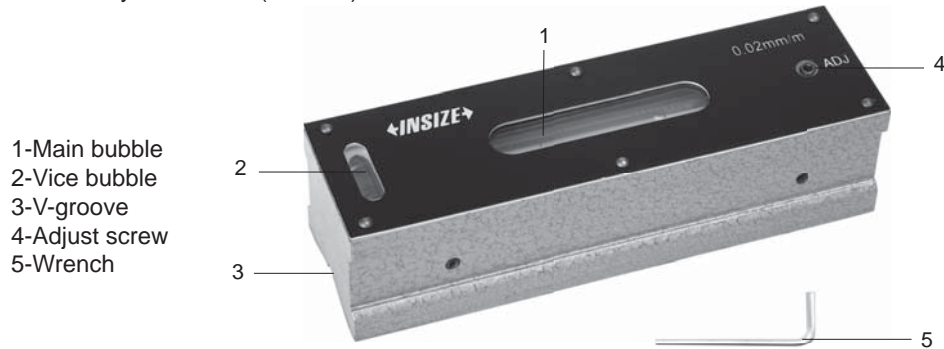




# OPERATION INSTRUCTION

## Block Level Series 4903

Sensitivity: 0.02mm/m(=0.001°)



1. The level and workpiece must be at the same temperature for at least 3 hours.
2. Set zero
  - a) Slide (not put) the level on a clean, plane and smooth surface. '-' side is on the left and '+' side is on the right (Fig.1).

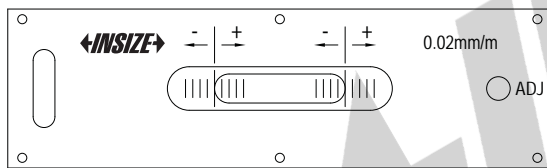


Fig.1

- b) After the bubble stops moving, read A on the scale (Fig.2).

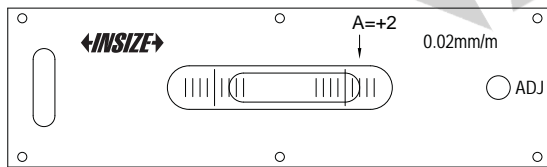


Fig.2

- c) Turn the level 180°, slide (not put) the level at the same position of the surface (Fig.3).

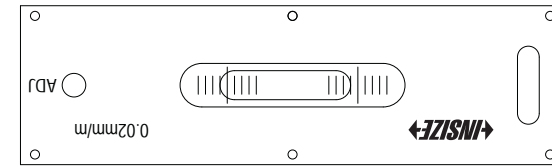


Fig.3

- d) After the bubble stops moving, read B on the scale (Fig.4).

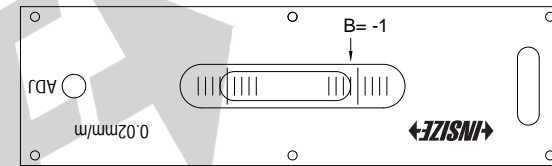


Fig.4

- e) If  $A-B \leq 1$ , the level can be used. If  $A-B > 1$  (in the above example,  $A-B=3$ ), rotate the adjust screw lightly until the bubble moves to the middle between A and B (Fig.5).

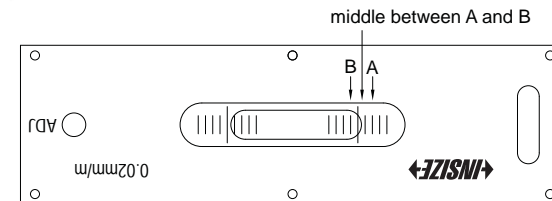


Fig.5

Please note: rotate the screw clockwise to move the bubble to the right side (Fig.6), rotate the screw counterclockwise to move the bubble to the left side.

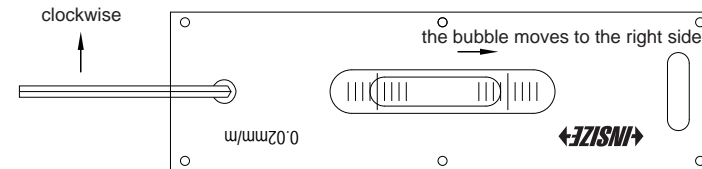


Fig.6

### 3. Measuring

- a) Slide (not put) the level on the surface of workpiece.
- b) After the bubble stops moving, read C on the scale (Fig.7).

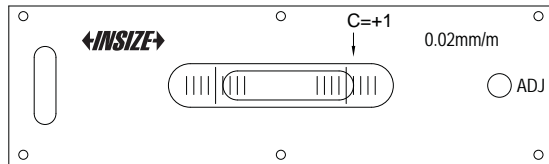


Fig.7

- c) Turn the level 180°, slide (not put) the level at the same position of the surface (Fig.8).

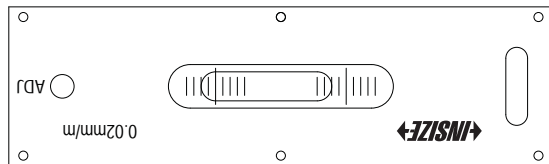


Fig.8

- d) After the bubble stops moving, read D on the scale (Fig.9).

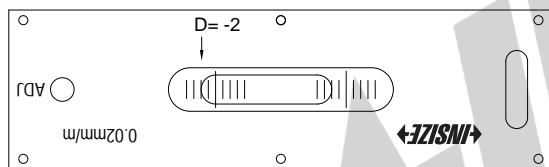


Fig.9

- e) The reading should be  $(C+D)/2$ .  
In the above example:  $C=+1$ ,  $D=-2$ ,  $(C+D)/2 = -1/2$ .